Wat	·k C	rder	ID	67580
** U I	\mathbf{n}	n uci	117	U/20U



Page 1

Mondaý, March 28, 2011 11:36:28 AM Item ID: D3219-1 **Revision 1D:** Plate Item Name: **Start Qty: 40.00 Start Date:** 3/28/2011 Req'd Qty: 40.00 Required Date: 3/31/2011 Reference:

Accept



Setup Start

Stop



ID:

Cust Item
Customer

Approvals:	Process Plan:QC:	Date: <u>//-03</u>	Tooling: SPC (Y/N):		ate:		R	Run Sta Sto	i indiiini e	
Sequence ID/ Work Center II	Operation	Date.	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	IIII III IIII IIII Insp. Stamp
Draw Nbr	Revision Nbr									-
D3219	Rev A									
Waterjet FLOW CNC Waterje	n n .		0.00				<u> 1811 -</u>	3-31	(S)	
QC Quality Control	QC2- Inspect parts off i	nachine FAI/FAIB	0.00				<u> 1811</u>	3 <u>-31</u>	_	

120

QC8- Inspect parts - second check

Quality Control

QC

Memo

				WO	RK ORDER CH	ANGES	-				
DATE	STEP	PF	ROCEDUR				Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		PAR #:									
	R	esolution:		1					d:	Date: _ 	
NCR:			WORK	ORDE	R NON-CONFO	DRMANCE	E (NC	R)			:
DATE	STEP	Description of NC		- .	Corrective Action	Section B	Sign	,	Verification		Approva
	O.E.	Section A	Init Chief	Eng	Action Descri		Date		Section C	Chief Eng	QC Inspect
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I											

Work Order ID 67580

Monday, March 28, 2011 11:36:28 AM



Page 2

Item ID:

D3219-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 3/31/2011

Plate

3/28/2011

Start Qty: 40.00 Req'd Oty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Start



Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation

QC:

Description

Small Fab

Memo

Memo

Memo

1-Deburr if necessary.

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty.

Reject Qty

Run

Reject Insp. Number Stamp

11/03/31

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging

Packaging

Identify as per dwg & Stock Location: LUM

*** STOCK IN STEP CELL***

0.00

0.00

1211.03.31

Dart Ae	rospace L	td								~
W/O:				WO	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE	CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No		PAR #:			· -					
	Res	olution:	Disp	sition	1:	QA: N/C C	losed:		Date: _	
NCR:			WORK (DRDE	ER NON-CONFORMA	NCE (NCI	₹)			
		Description of NC			Corrective Action Section	В	Verific	cation	Approval	Approva
DATE	STEP	Section A	Initia Chief E		Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspecto

Work Order ID 67580

Monday, March 28, 2011 11:36:28 AM



Page 3

Item ID:

D3219-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Required Date: 3/31/2011

3/28/2011 **Start Qty: 40.00**

Req'd Qty: 40.00

QC21- Final Inspection - Work Order Release

Cust Item ID: Customer:

Reference:

Start Date:

nn	201	رم,	•	

Process Plan:

Date:

Tooling:

Date:

Start

Stop



Approvals:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/

Work Center ID

160

0.00

0.00

Tool ID

Tool # Plan Code Qty

Reject Accept Qty

Run

Reject Number Stamp

Insp.

Quality Control

Memo

MF 11-04-01

Operation

Description

Dart Ae	rospace L	td									-
W/O:				WOF	K ORDER CHANG	ES					•
DATE	STEP	PRO	OCEDURE	CHANG	AE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·					
Part No):	PAR #:	Fault	Catego	ry:	_ NCF	R: Yes	No DQ	A:	Date:	•
	Res	olution:	Dispo	sition:		_ QA:	N/C C	losed:		Date: _	
NCR:			WORK C	RDE	R NON-CONFORM	ANCE	(NCI	R)			
		Description of NC		С		ion B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initia Chief E		Action Description Chief Eng		Sign Date	& Sect	ion C	Chief Eng	QC Inspecto
:											
1											
										i	

Picklist Print

Monday, March 28, 2011 11:36:34 AM

Work Order ID: 67580

Parent Item:

D3219-1

Parent Item Name: Plate



Start Date: 3/28/2011

Required Date: 3/31/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP A□04.04.19□New issue□KJ/JLM□

ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	154.0000	0.0964	4.058947	(3, 1	
										R11-	3-31		

6061-T6 .125 Sheet

<u>Location</u>	Loc Qty	Loc Code
MAT021	154	
113608	130	
116700	24	
•		



Dart Ae	rospace l	Ltd								
W/O:				WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE	CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		PAR #:								
	Res	solution:	Dispo	sitior);	QA: N/C C	osed:		Date: _	
NCR:			WORK C	RD	R NON-CONFORMAN	ICE (NCF	₹)			
		Description of NC			Corrective Action Section		Verifi	cation	Approval	Approva
DATE	STEP	Section A	Initia Chief E		Action Description Chief Eng	Sign & Date	k Sect	tion C	Chief Eng	QC Inspecto
		•								
				; in the control of t						

DART AEROSPACE LTD	Work Order:	1,7580
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	1317	7		V 1802	
2.293	+/-0.005	7.295	+		V	
2.965	+/-0.010	2.968	t		V	
0.566	+/-0.010	.568	~		V	
0.375	+/-0.010	.376	×		V	
R0.125	+/-0.010	.135	Ά		R.G.	
13.9°	+/-0.5°	13.90	>			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-3-3,	Date: 4(03/3/	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM	
В	07.09.06	13.9° dimension added	KJ/JLM ,	
C	08.04.15	0.125 dimension removed	KJ/DD 🚓	<i>N</i>

Dart Aerospac	e Lt	d
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W/O:			W	ORK ORDER CI	HANGES					
DATE	STEP	PRC	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1	
									<u> </u>	
				·						
Part No:		PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition	on:	QA: N/C Closed: Date:					
NCR:		\	WORK ORD	ER NON-CONF	ORMANC	E (NCR))			
DATE	STEP	Description of NC		Corrective Action	Section B	0: 0		cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Descr Chief Eng		Sign & Date		tion C	Chief Eng	QC Inspector
						:				

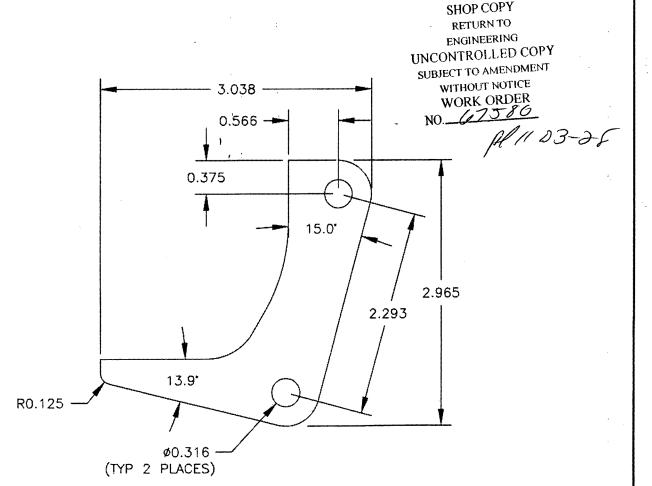
^{*}H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





1	DESIGN	DRAWN BY		AEROSPACE WKESBURY, ONTARIO, CAN		
	CHECKED,	APPROVED,	DRAWING NO.			REV. A
-	#	4	D3219		SHEET	1 OF 1
	DATE		TITLE			SCALE
	03.10.10		PLATE			1:1
	A	03.10.10	NEW ISSUE			





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)

(REF DART SPEC M6061T6S.125)

- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O: _		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #: Fault Category:	NCI	R: Yes	No DQ	۸:	_ Date: _			

QA: N/C Closed: _____ Date: ____

Resolution: _____ Disposition: ____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP	T	Description of NC		Corrective Action		Section B		Approval	Annewal
	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector
								·	